

Date: Monday, 4/23/2007 1:52:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 31990		
Estimate Number	: 12736		
P.O. Number	: N/A	Part Number	: D353515
This Issue	: 4/23/2007 S.O. No. : N/A	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: X B PH 07.04.28
Previous Run	: 30750	Material	: N/A
Written By	:	Due Date	: 4/30/2007
Checked & Approved By	: <u>PH 07.04.28</u>	Qty:	25 Um: Each
Comment	: Est Rev:A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M/01873

SAD 07/04/28

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: BProg Rev: B

SAD 07/04/28

(26)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/28

(26)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/04/30

(25)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

SB 07/04/30

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31990

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



207-05-01 (26)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M1101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

281

07-05-03

(26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(26X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/05/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(26X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

m-l 07/05/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

Job Completion



u 07.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

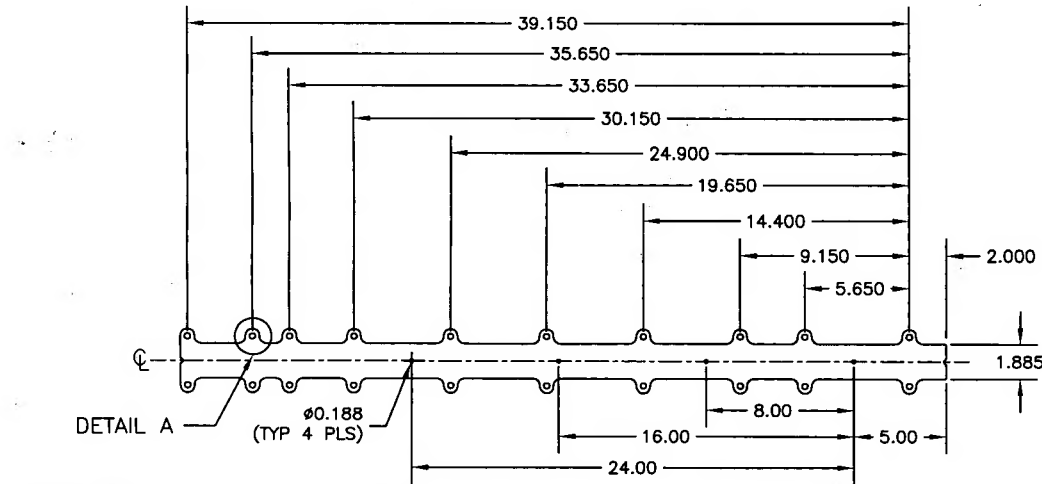
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

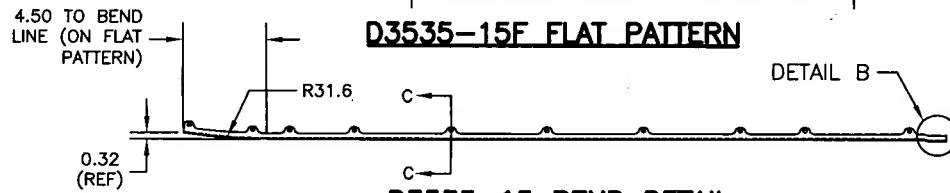
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

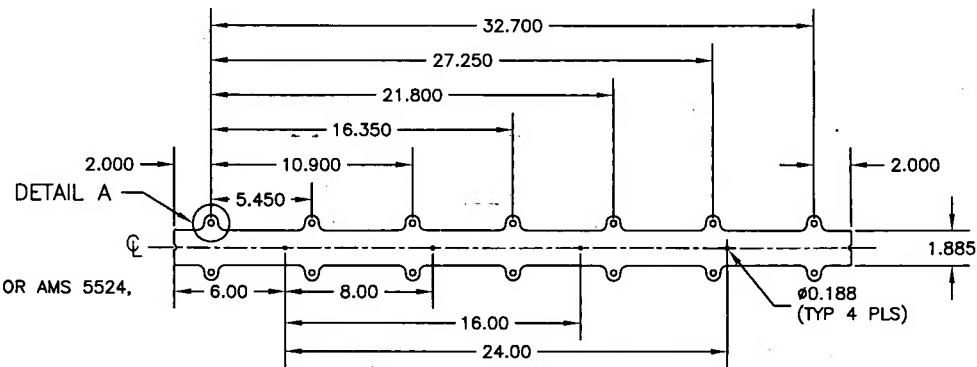


D3535-15F FLAT PATTERN

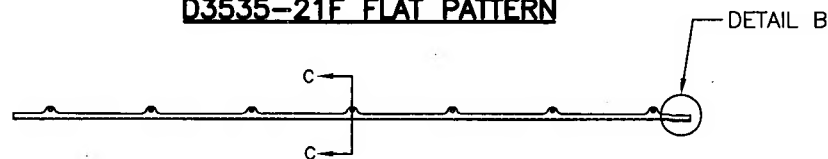


D3535-15 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31990



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

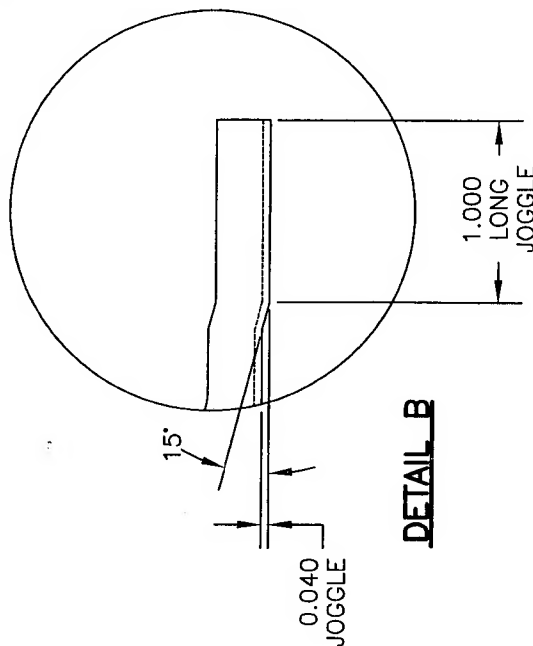
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

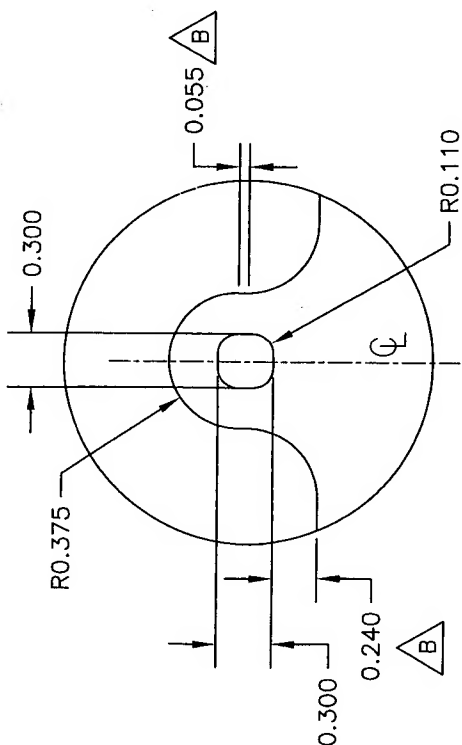
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO. D3535	TITLE WEARSHOE	SHEET 2 OF 7
DATE 07.04.17			SCALE 1:10	

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

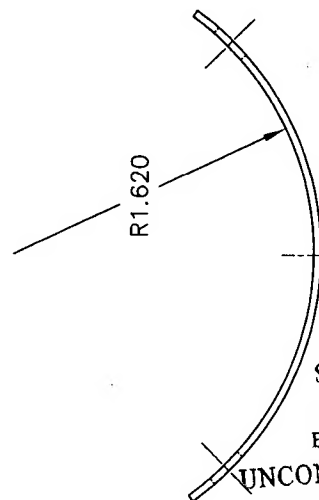
PRELIMINARY ISSUE



DETAIL B



DETAIL A



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31990**

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD		Work Order: 31991
Description: WEARSHOE		Part Number: D 353521
Inspection Dwg: D 3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.885	± 0.010	1.888	✓	Vern	
B	2.000	± 0.010	2.005	✓	Vern	
C	5.650	± 0.010	5.648	✓	Vern	
D	9.150	± 0.010	9.150	✓	M-T	
E	14.400	± 0.010	14.400	✓	M-T	
F	19.650	± 0.010	19.650	✓	M-T	
G	24.900	± 0.010	24.900	✓	M-T	
H	30.150	± 0.010	30.150	✓	M-T	
I	33.650	± 0.010	33.650	✓	M-T	
J	35.650	± 0.010	35.650	✓	M-T	
K	39.150	± 0.010	39.150	✓	M-T	
L	Ø 0.188	$+0.005$ -0.001	Ø 0.188	✓	Vern	
M	24.00	± 0.030	24.00	✓	M-T	
N	16.00	± 0.030	16.00	✓	M-T	
O	8.00	± 0.030	8.00	✓	M-T	
P	5.00	± 0.030	5.007	✓	Vern	
Q	0.300	± 0.010	0.300	✓	Vern	
R	0.300	± 0.010	0.297	✓	Vern	
S	Ø 0.038	± 0.010	Ø 0.036	✓	Vern	
T						
U						
V						
W						
X						
Y						

Measured by: JAD	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/04/21	Date: 07/04/20	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved